

5/24

DART AEROSPACE LTD	Work Order:	23460 B
Description: Gas Spring	Part Number:	D2807
Dwg: D2807 Rev. C	Qty:	60
Page 1 of 1		

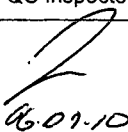
Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	KL	05.07.19	60
2	PG	Issue P/O: <u>2008151</u> Order as per Dwg D2807 Possible supplier: ArvinMeritor Motion Control Systems Material release note is required	KL	05.06.02	60
3	RG	Receive and Inspect for transit damage Ensure the material release note is attached	KL	05/07/19	59
4	QC6	Inspect dimensions as per Dwg D2807	J	06.01.10	35
5	GA	Install lugs and crimp as per Dwg D2807 Pick: Qty Part Number Description Batch 2 D2807-3 Lug 1 B 23915 623479	FF	06-01-11	35
6	QC5	Inspect work to Step 5	J	06-02-11	35
7	ST	Identify and Stock Loc: 379	CL	06/01/11	33
8	AC	Cost / part:			
9	DC	Close W/O Inspect Level 21			

Rev	Date	Change	Revised By	Approved
A	00.11.09	New Issue	EC	
B	00.11.15	Added step 6	EC	
C	05.04.28	Reformat; Added Step 6 & 7	KJ/JLM	
D	05.06.21	Removed painting; Changed supplier	KJ/JLM	

RELEASED
15.06.21



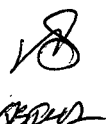
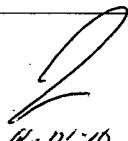
Dart Aerospace Ltd
W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06/01/10	5	write the dt 8791 sig on W/O Add to step 5 permanent change	SB	06/01/10			 06-01-10

NCR:

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/01/10	5	1 piece thread was damaged		Scrap - destroy	Jan 10-06 FF	 06-01-10		 06-01-10

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

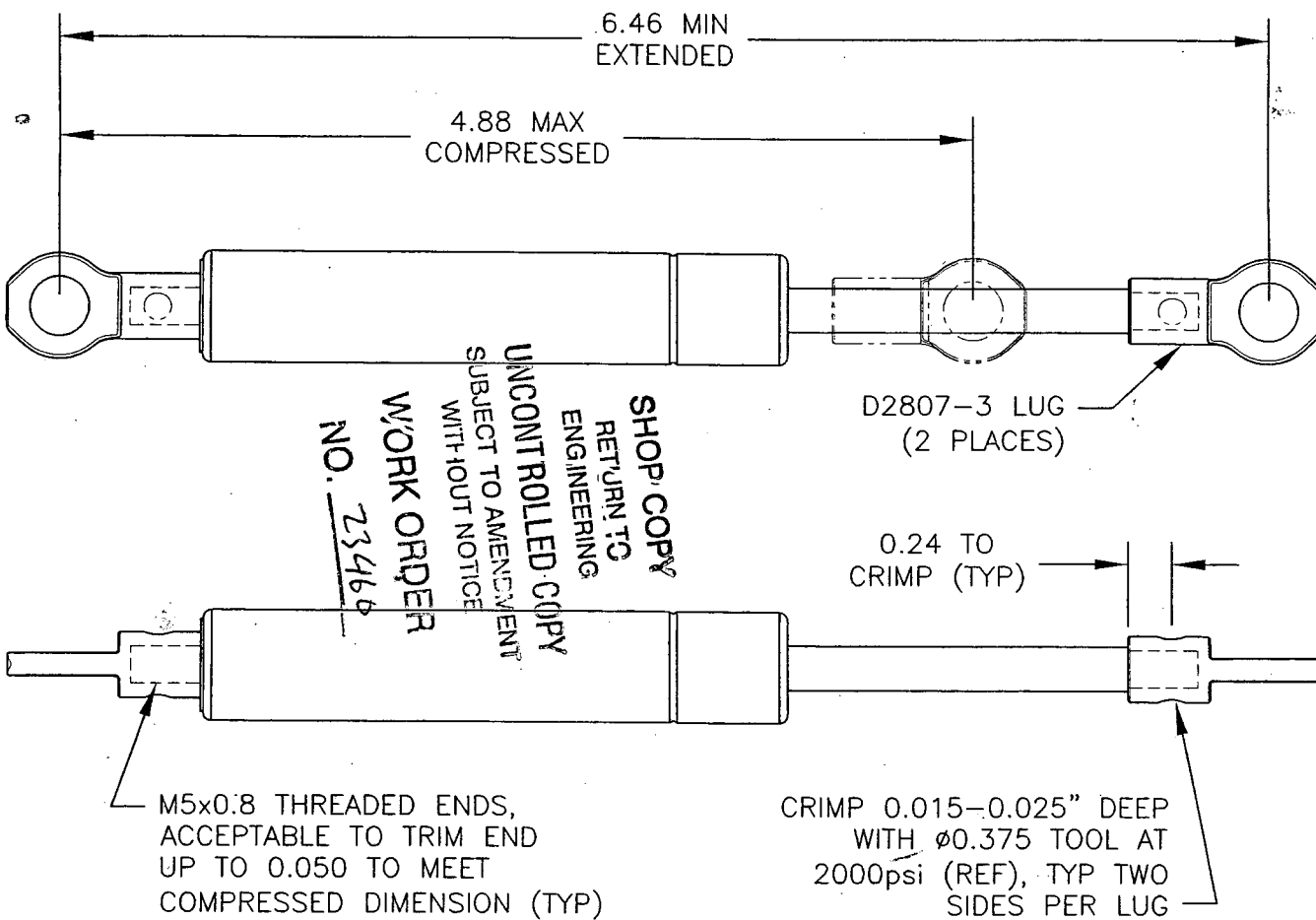
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

RELEASED
05-06-16

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE	05.05.25	TITLE	D2807	REV. C
			GAS SPRING	SHEET 1 OF 2
A	00.11.03		NEW ISSUE	SCALE
B	05.03.16		ADD FINISH	1:1
C	05.05.25		CHANGE SPRING TO SS, ADD -3 LUG	



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WORK ORDER
NO. 23460

D2807 GAS SPRING

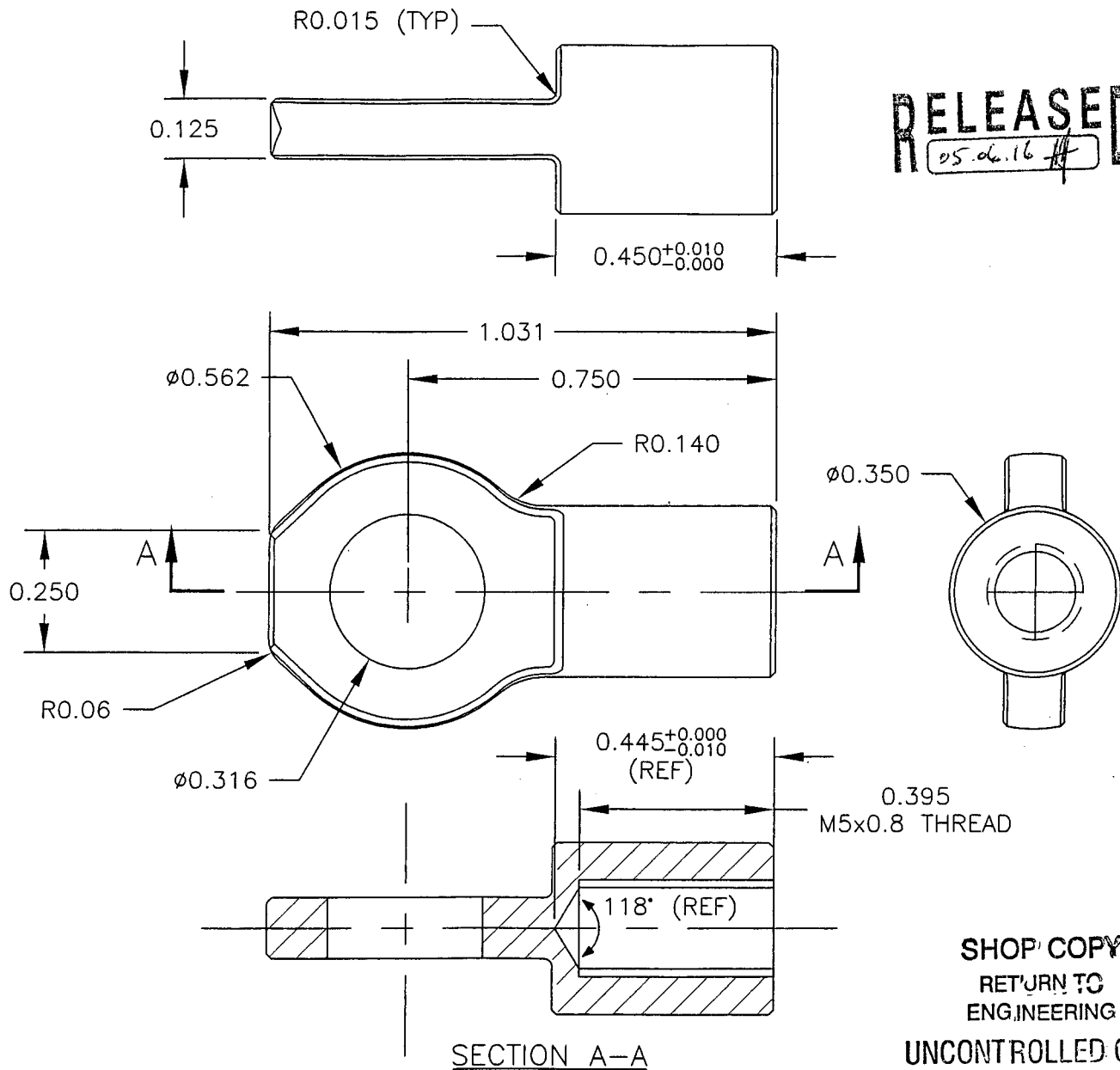
- 1) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX
M5x0.8 THREADS

POSSIBLE SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK
P/N: SXF6S6050080S6L-115N
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)

- 3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	DRAWN BY	DART AEROSPACE LTD	
CP	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
<i>[Signature]</i>	<i>[Signature]</i>	D2807	SHEET 2 OF 2
DATE	TITLE	SCALE	
05.05.25	GAS SPRING	3:1	



RELEASED
05.06.16 *[Signature]*

D2807-3 LUG

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.015
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER

NO. 234160

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 31, 2005
03:20 pm

Work Order No : 0023460
Project Name : D2807
Project For : WK524
Work Order Type : Main
Main WO Number :
House Part Number : D2807
Description : Support Prop
Manufactured : Yes
Amount Req'd : 60
Amount Done : 0
Start Date : 05-31-05
Est Finish Date : 06-30-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods.

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

PAID PROFORMA - C

DART AEROSPACE

17999

46

CHECK CUSTOMER HAS PAID
CARRIAGE BEFORE SHIPPING

CUSTOMER REF. No.

2008151

V.A.T. REGISTRATION No. GB 738 8577 71

W ORDBER

[illegible]

Cam 001

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Main Fax: +44 (0)116 274 3620
E-mail - info.amcl@arvinmeritor.com
Website: www.camloc.com

TNT
GE50169785WW

✓
Certified that the whole of the supplies detailed hereon
have been inspected and tested and unless otherwise stated
conform in all respects with the contract/purchase order
requirements.

SIGNED _____

POSITION _____

DATE _____

